

**Work Order ID 116545**

April-17-14 9:24:04 AM

**\*116545\***

Page 1

Item ID: D315-670-011

Revision ID:

Item Name: Bearpaw

Start Date: 4/17/14 Start Qty: 1.00 **\*1\***Required Date: 4/17/14 Req'd Qty: 1.00 **\*1\***

Reference: disassemble

Accept

**\*N900040100\***Setup Start **\*NS1\***Stop **\*NS2\***

Cust Item ID:

Customer:

Approvals: Process Plan: W Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_

Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2432	Rev H

150

Pick Kit

0.00

**\*150\***

Packaging

Packaging

Memo

PULL FROM STK.

1 X D315-670-011 B112647

DISASSEMBLE KIT COMPLETELY, RETURN ITEMS TO STK

0.00

DAS  
32  
9.89

14/4/17 ①

180

QC21- Final Inspection - Work Order Release

0.00

**\*180\***

QC

Quality Control

Memo

0.00

11.5 14-04-17

W 14.4.17

# Picklist Print

April-17-14 9:24:03 AM

Page 1

Work Order ID: 116545

**\*116545\***

Parent Item: D315-670-011

**\*D315-670-011\***

Parent Item Name: Bearpaw

Start Date: 4/17/14

Required Date: 4/17/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 07-01-03 JLM  
IPP Rev:B 08-01-09 Added Step 2 JLM Verified By:EC  
IPP Rev:F 08-10-15 New Manufacturing Method JLM Verified  
By:EC IPP RevG: revise seq in route DD 10.01.13 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4-17A <b>*AN4-17A*</b> Bolt		Purchased		No			Each	528.0000		-12			DAS 32 9-89
					<u>Location</u>			<u>Loc Qty</u>					
					ST357			12					
					124858			12					
					ST515			516					
					M127817			266					
					M128813			250					
D2182B050 <b>*D2182B050*</b> Clamp Cushion Black		Manufactured		No			Each	46.0000		-6			DAS 32 9-89
					<u>Location</u>			<u>Loc Qty</u>					
					ST409			46					
					113375			46					
D2274 <b>*D2274*</b> Radius Block		Manufactured		No			Each	545.0000		-12			DAS 32 9-89
					<u>Location</u>			<u>Loc Qty</u>					
					FG			12					
					86855			12					
					ST008			533					
					109534			196					
					110264			3					
					112466			322					
					99005			12					

# Picklist Print

April-17-14 9:24:03 AM

Page 2

Work Order ID: 116545

**\*116545\***

Parent Item: D315-670-011

**\*D315-670-011\***

Parent Item Name: Bearpaw

Start Date: 4/17/14

Required Date: 4/17/14

Start Qty: 1.00

Required Qty: 1.00

D2432

Manufactured No

Each

1.0000

-2

**\*D2432\***

Bearpaw 19" X 24"

**\*\***

B 36590

DAS

32

9-89

Location

Loc Qty

Loc Code

ST

1

111630

1

Each

743.0000

-12

D2529

Manufactured No

**\*D2529\***

Washer

**\*\***

B 35356

DAS

32

9-89

Location

Loc Qty

Loc Code

ST011

743

109580

19

110318

212

115153

500

99918

12

Each

4.0000

1

D315-670-011

Manufactured No

**\*D315-670-011\***

Bearpaw

**\*\***

Location

Loc Qty

Loc Code

FG011

3

111560

3

FG012

1

112647

1

14.04.17

April-17-14 9:24:03 AM

Shop Packet Print

Page 2

# Picklist Print

April-17-14 9:24:03 AM

Page 3

Work Order ID: 116545

**\*116545\***

Parent Item: D315-670-011

**\*D315-670-011\***

Parent Item Name: Bearpaw

Start Date: 4/17/14

Required Date: 4/17/14

Start Qty: 1.00

Required Qty: 1.00

MS21042L4

Purchased

No

Each

8,601.000

-12

**\*MS21042L 4\***

Locknut

**\*\***

*M105009*

DAS

32

9-89

## Location

## Loc Qty

## Loc Code

ST314

44

m126015

12

m126275

32

ST509

8546

m127255

71

m127813

1083

m128300

2392

m128798

5000

ST518

11

m127376

11

NAS1149D0463J

Purchased

No

Each

7,047.000

-24

**\*NAS1149D0463J\***

WASHER

**\*\***

*M100906*

DAS

32

9-89

## Location

## Loc Qty

## Loc Code

ST294

127

M127693

127

ST510a

6920

M127813

22

M127904

3000

M128591

3898

*As 960 50476*

*14/7/17*

April-17-14 9:24:04 AM

Shop Packet Print

Page 3



QM Type: Production																													
Status	Item ID	Rev	Name	Start Date	Quantity	UOM	Op Date	Sec	rap	ap	Quam	me	N	C	IL	Sort	me	Offset	in	Ty	1	Per	Och	to	Vore	Ce	Last	Id	Da
	AN4-17A		Bolt	1/01/08	12....	Ea		150	0...	0.0...					0	0	M...	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>						1/1...	12...		
	D2182B		Seal(\$Per Foot)	12/05/09	2.5...	f		150	0...	0.0...					0	0	M...	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>						1/2...	12...		
	D2274		Radius Block	12/05/09	12....	Ea		150	0...	0.0...					0	0	M...	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>						1/1...	12...		
	D2432		Bearpaw 19" X 24"	12/05/09	2.0...	Ea		150	0...	0.0...					0	0	M...	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>						1/1...	12...		
	D2438		Clamp	12/05/09	6.0...	Ea		150	0...	0.0...					0	0	M...	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>						1/1...	12...		
	D2529		Washer	12/05/09	12....	Ea		150	0...	0.0...					0	0	M...	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>						1/1...	12...		
	MS21042L4		Locknut	1/01/08	12....	Ea		150	0...	0.0...					0	0	M...	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>						1/1...	12...		
	NAS1149D0463J		WASHER	10/03/13	24....	Ea		150	0...	0.0...					0	0	M...	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>						10/...	10...		

4

Date: Monday, 1/7/2008 11:13:37 AM  
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services  
Job Number : 36595  
Estimate Number : 12617  
P.O. Number : N/A  
This Issue : 1/7/2008 S.O. No. : N/A  
Prsht Rev. : NC  
First Issue : N/A Type : MACHINED PARTS  
Previous Run : 36333  
Written By :  
Checked & Approved By : 08.01.07  
Comment : Est Rev:A New Issue 07-01-03 JLM

Drawing Name : BEARPAW KIT (19"X24")  
Part Number : D315670011  
Drawing Number : D2432 REV F3  
Project Number : N/A  
Drawing Revision : F3  
Material : N/A  
Due Date : 1/23/2008 Qty: 4 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 DC DOCUMENT CONTROL



KS 08/01/07

Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D315-670-011 CHG001

08/01/15

2.0 MUHMWB10 UHMW 1" Black



Comment: Qty.: 6.8250 sf(s)/Unit Total: 27.3000 sf(s)

blank: 19.500" x 24.00" x 1.00" thick (+0.030/-0.000) per DSK086-5

Material: Black UHMW 1"

(MUHMWB10)

Batch: M106717 → 12' long x 6 pc >

DTP 08/01/11

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Note: (2) bearpaws for (1) Kit

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio and Dwg D2432 Identify as D2432F

3-Deburr

DTP 08/01/11 / J.L 08/01/13

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L 08/01/13